

Work Order ID 70453

Wednesday, June 08, 2011 3:45:53 PM



Page 1

Item ID: D3021-041

Accept



Setup Start



Revision ID:

Item Name: Tube Assembly

Stop



Start Date: 6/8/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

MF

Date:

11-06-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3021

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut tube as per Dwg D3021

2-Drill tube as per Dwg D3021 using D8622

3-Deburr

4-Weld as per Dwg D3021 QSI004

A/R 4130 Rod Batch: *M100075**EZ 11-6-13 (X1)*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

1 0 BE 11/06/13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sub 114

②

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:30
320 °F
9:00

IX of M-11/06/14

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 - BR 11-6-14

W/O:		WORK ORDER CHANGES						
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Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: *G.A*

0.00



Packaging

Memo

w/o

0.00

Packaging

*70006**ES/06/14*

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/06/14**ME 11-06-14*

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Wednesday, June 08, 2011 3:45:44 PM

Page 1

Work Order ID: 70453



Parent Item: D3021-041



Parent Item Name: Tube Assembly

Start Date: 6/8/2011


Required Date: 6/10/2011

Start Qty: 1.00

Required Qty: 1.00


Comments: IPP 01.10.23 New Issue SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3017-11  cap		Manufactured	No			100	Each	24.0000	2	2			
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Location	Loc Qty	Loc Code
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WA	24	
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M4130NT0.750W.049  4130 RD Tube .750 x.049W		Purchased	No			100	f	100.0990	2.0833	2.192947			
---	--	-----------	----	--	--	-----	---	----------	--------	----------	--	--	--

Location	Loc Qty	Loc Code
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MAT033	100.099	
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110740	1.129	
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117691	46.97	
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117973	52	
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EL 11-6-13

2

EL 11-6-13

2.19

W/O:		WORK ORDER CHANGES						
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

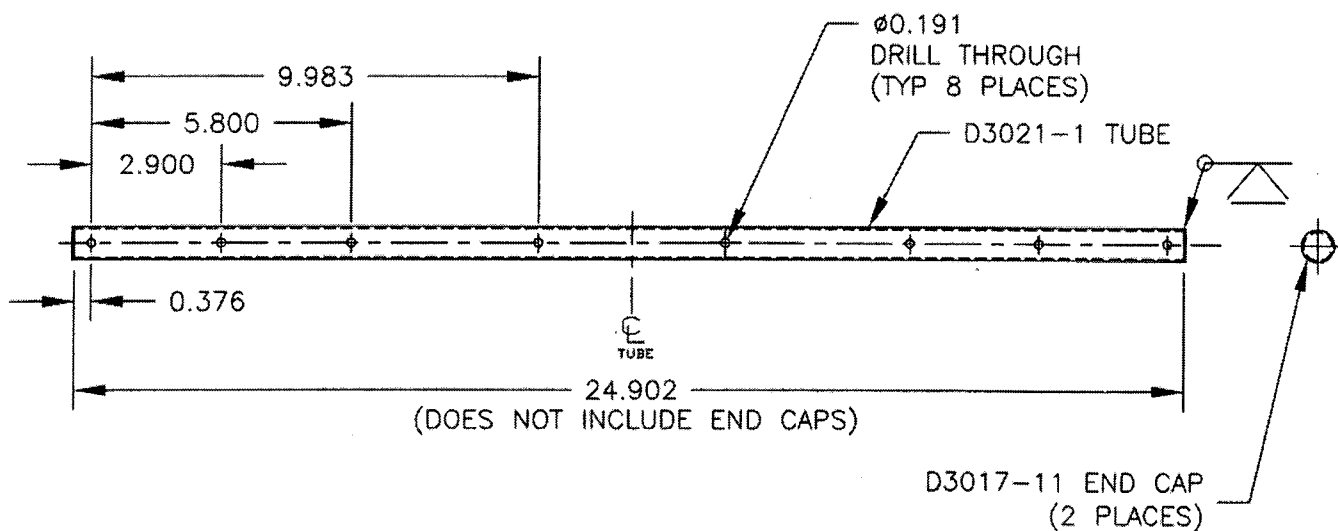
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3021	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE TUBE ASSEMBLY	SCALE 1:4
A	01.05.18	NEW ISSUE	

CP 10/17/18



D3021-041 TUBE ASSEMBLY
(D3021-1 TUBE)

NOTES:

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) MATERIAL: AISI 4130 TUBE, $\phi 0.75$ DIA x 0.049 WALL (M4130N-T0750W049)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

RELEASED
01.05.30

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